



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D3508-3**Job Sheet 183565****Part No:** D3508-3**Job Qty:** 2 ea**Part Name:** Wearplate Fwd Center**Part Weight:** 0 lbs**Status:** Scheduled**Priority:** Medium**Job Created:** 9/20/18**Job Tracking No:****Due Date:** 10/19/18**Created By:** Jesse White**Type:** Stock**Description:** SIOP

Note: DWG REV C IPP Rev:A New Issue 06-06-20 JLM IPP Rev:B Now SS as per Rev B 06-12-15 JLM IPP Rev:C
Rev C dwg 07-12-06 DD

Ship Via:**Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	10/19/18	10/19/18	0.00	0.00	Start Up Waterjet		SC 10/19/18
100	Waterjet	2 pcs	10/19/18	10/19/18	0.00	0.28	Waterjet1		SC 10/19/18
110	QC	2 pcs	10/19/18	10/19/18	0.00	0.00	QC2 Waterjet-2		SC 10/19/18
120	QC	2 pcs	10/19/18	10/19/18	0.00	0.00	QC8-2		SEP 26 2018 68
130	Brake NC	2 pcs	10/19/18	10/19/18	0.46	0.12	Brake NC 1		SEP 26 2018 68
140	QC	2 pcs	10/19/18	10/19/18	0.00	0.00	QC5		OCT 10 2018 68
150	Powdercoat	2 pcs	10/19/18	10/19/18	0.00	0.05	Powdercoat3		BL 8E818-10-18 68
160	QC	2 pcs	10/19/18	10/19/18	0.00	0.00	QC3		OCT 17 2018 68
170	Packaging	2 pcs	10/19/18	10/19/18	0.00	0.00	Packaging3-1		FP-002 10/18/18 68
180	QC21-SA	2 Ea	10/19/18	10/19/18	0.00	0.00	QC21		DAG 21 OCT 17 2018 9-55

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S20GA	304/316 .040 Sheet	1.4680 sf (.734 ea)	90-Start up Operation	5090402

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304S20GA	1	291	0

Part Specifications

Specifications could not be found.

M138839 START: 7:50
TEMP: 320°
FINISH: 8:00

Plex 9/20/18 1:18 PM dart.white.jesse



Dart Aerospace Ltd.
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CANADA
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www.dartaerospace.com

Container No: S112383



Part: D3508-3

Job No: 183565

Serial No/Batch: S112383

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 09/21/18

STC 01115000 0803
DVB 0803
01115000 0803
DVB 0803

DART AEROSPACE LTD		Work Order:	183565
Description: Wearplate		Part Number:	D3508-3
Inspection Dwg: D3508 Rev: C		Page 1 of 1	

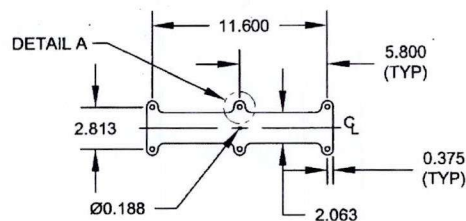
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

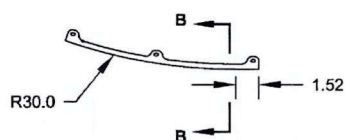
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.063	+/-0.010	2.065	1		VISEOL TYPE	
2.813	+/-0.010	2.815	1			
0.375	+/-0.010	0.375	1			
5.625	+/-0.010	5.625	1			
33.750	+/-0.010	33.750	1			
37.13	+/-0.030	37.13	1			
Ø0.188	+0.005/-0.001	Ø0.191	1			
0.300	+/-0.010	0.303	1			
0.300	+/-0.010	0.304	1			
0.038	+/-0.010	0.035	1			

Measured by:	Sc	Audited by:		Prototype Approval:	N/A
Date:	18/09/21	Date:		Date:	N/A

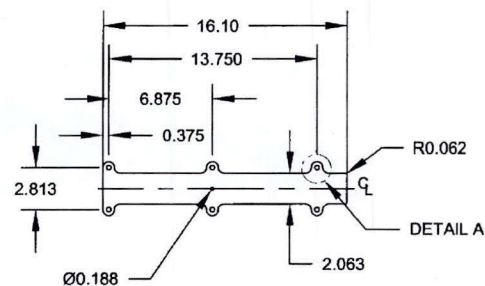
Rev	Date	Change	Revised by	Approved
A	08.04.15	New Issue	KJ/DD	AS



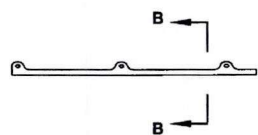
D3508-1 FLAT PATTERN



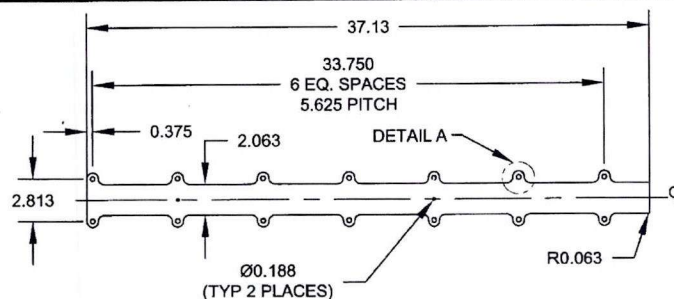
D3508-1 BENDING DETAIL
(MAKE FROM D3508-1F)



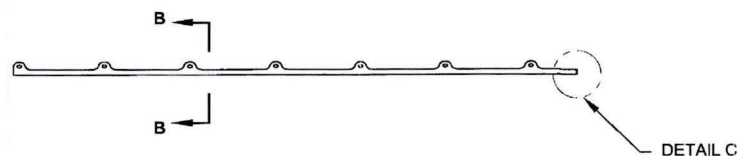
D3508-7F FLAT PATTERN



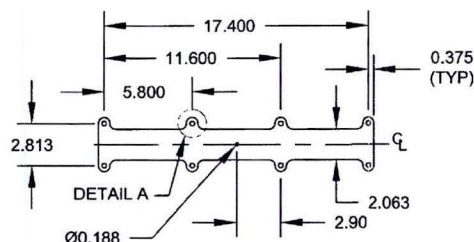
D3508-7F BENDING DETAIL
(MAKE FROM D3508-7F)



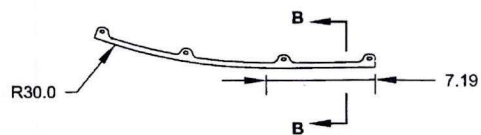
D3508-3 FLAT PATTERN



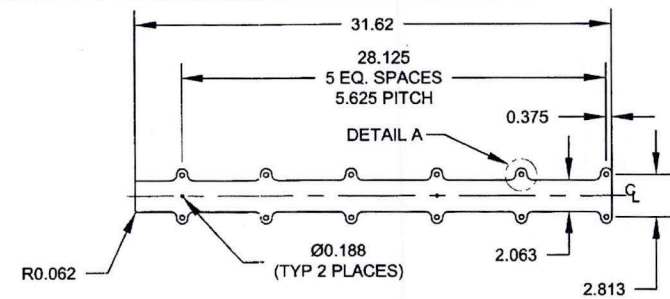
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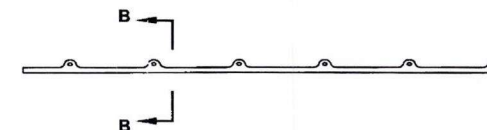
D3508-9F FLAT PATTERN



D3508-9F BENDING DETAIL
(MAKE FROM D3508-9F)



D3508-5 FLAT PATTERN



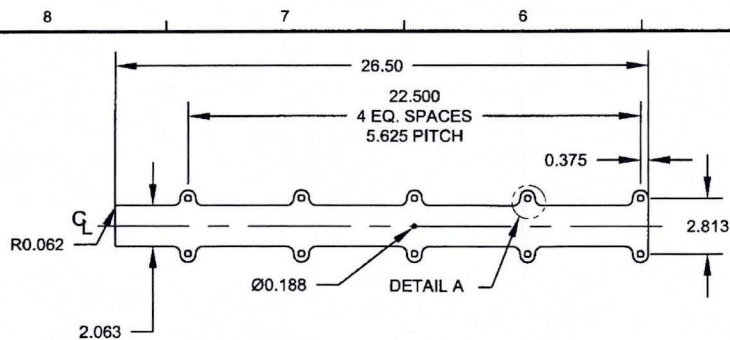
D3508-5 BENDING DETAIL
(MAKE FROM D3508-5F)

NOTES:

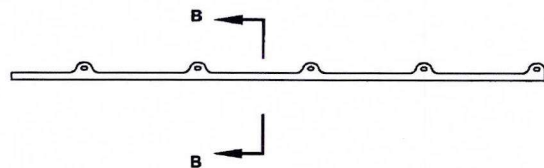
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
(REF. DART MATERIAL SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.015
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: D3508-1 - 0.47 lbs, D3508-3 - 0.95 lbs, D3508-5 - 0.77 lbs,
D3508-7 - 0.39 lbs, D3508-9 - 0.45 lbs, D3508-11 - 0.64 lbs
D3508-13 - 0.25 lbs

RELEASED
07.11.16

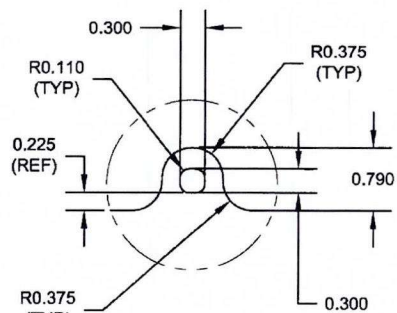
C	ADD -9/-11/-13 MOVE TAB OUTBOARD (2.813 WAS 2.733) CHANGE DRAWING FORMAT	PH	07.04.20
B	CHANGE STAINLESS STEEL, WIDEN	PH	06.10.27
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE USA, INC	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3508	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE	1:8
DATE	07.04.20	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMERCIALIZED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



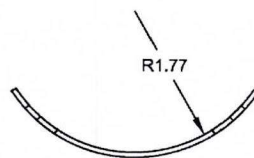
D3508-11F FLAT PATTERN



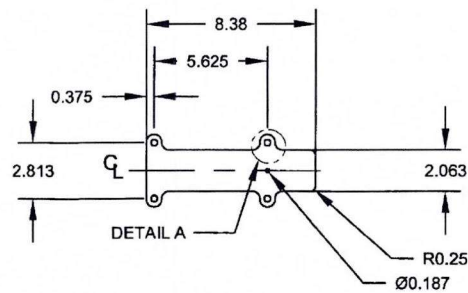
D3508-11 BENDING DETAIL
(MAKE FROM D3508-11F)



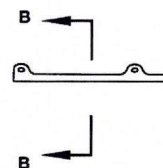
DETAIL A
(SCALE 2:3)



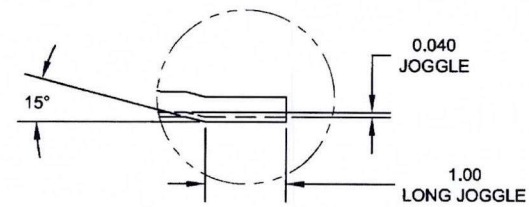
SECTION B-B
(SCALE 2:3)



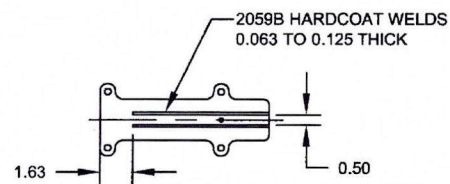
D3508-13F FLAT PATTERN



D3508-13 BENDING DETAIL
(MAKE FROM D3508-13F)



DETAIL C
(SCALE 1:2)



D3508-13 WELDING DETAIL

RELEASED
07-11-16

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED	PH	DRAWING NO.	REV. C
MFG. APPR.	PH	D3508	SHEET 2 OF 2
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARPLATE	1:
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